

Date: Tuesday, 10/06/2008 12:54:31 PM  
 User: Julie Lecocq

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 39791	Part Number	: D356413
Estimate Number	: 12788	Drawing Number	: D3564 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 10/06/2008	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 23/06/2008
Previous Run	: 38253	Qty:	30 Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 08.6.10</u>		
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet  8.
		Comment: Qty.: 0.2331 sf(s)/Unit Total : 6.9930 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>108156</u> <u>RB 8-6-12 U</u>
2.0	WATER JET	FLOW WATER JET  
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: <u>D</u> <u>RB 8-6-12</u> Prog Rev: <u>D</u>
		2-Deburr if necessary <u>RB 8-6-12</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE   <u>RB 8-6-12</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK   <u>S 08/06/12 X33</u> <i>coconite</i>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE  
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT <u>8179</u> and DT <u>8155</u> <u>SB 08/06/16</u> <u>33</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:31 PM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39791

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

8/06/16 (23)

7.0 POWDER COATING

POWDER COATING



M10S642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 2:30

OVEN TEMPERATURE: 315

FINISH TIME: 4:00

F/AQB

08/06/17

X33

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/06/18

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-21

F 08/06/18 (33)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/19 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39791
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564 Rev: D		Page 1 of 1

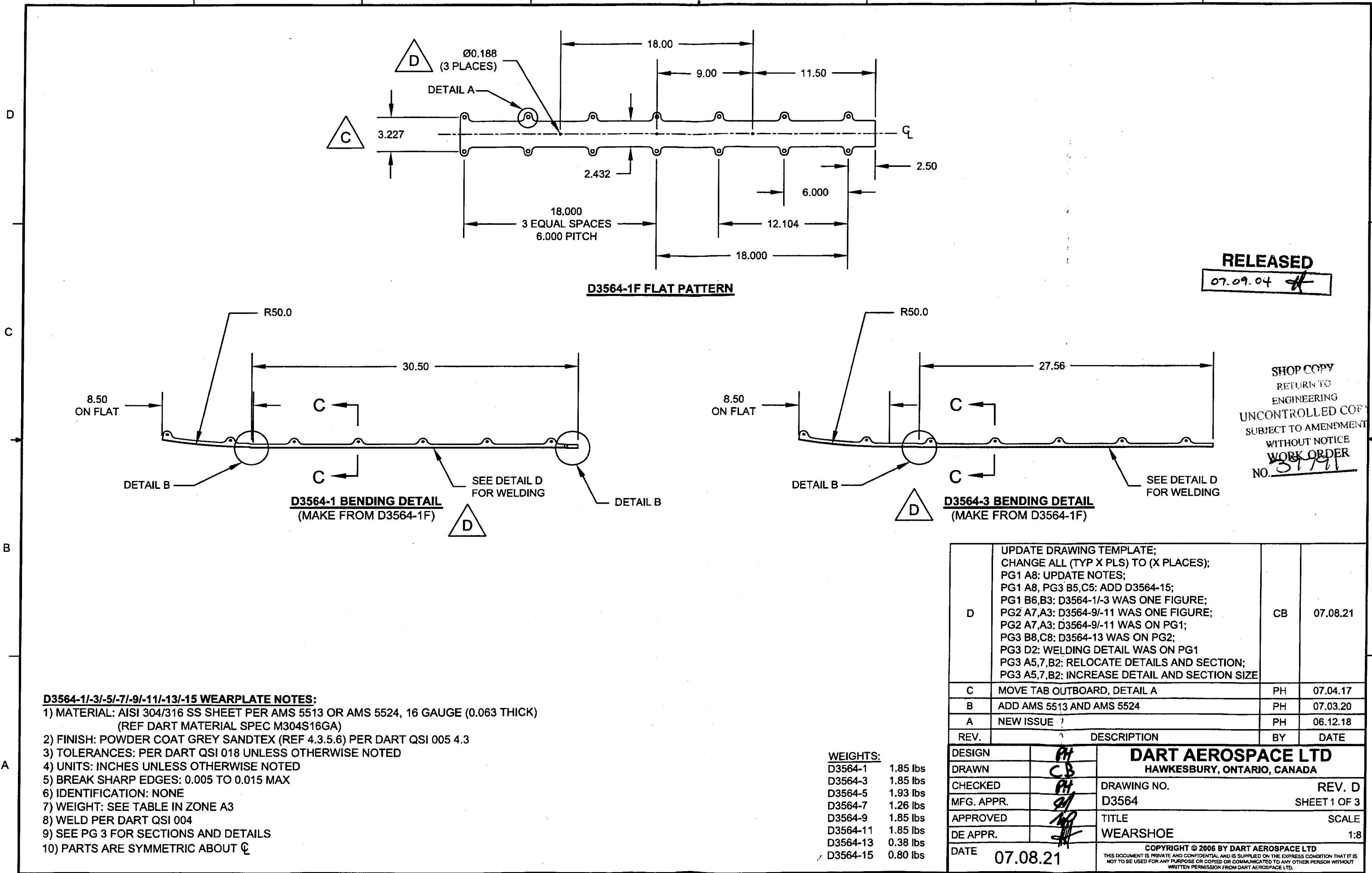
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>VB</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-6-12	Date:	08/06/12	Date:	N/A

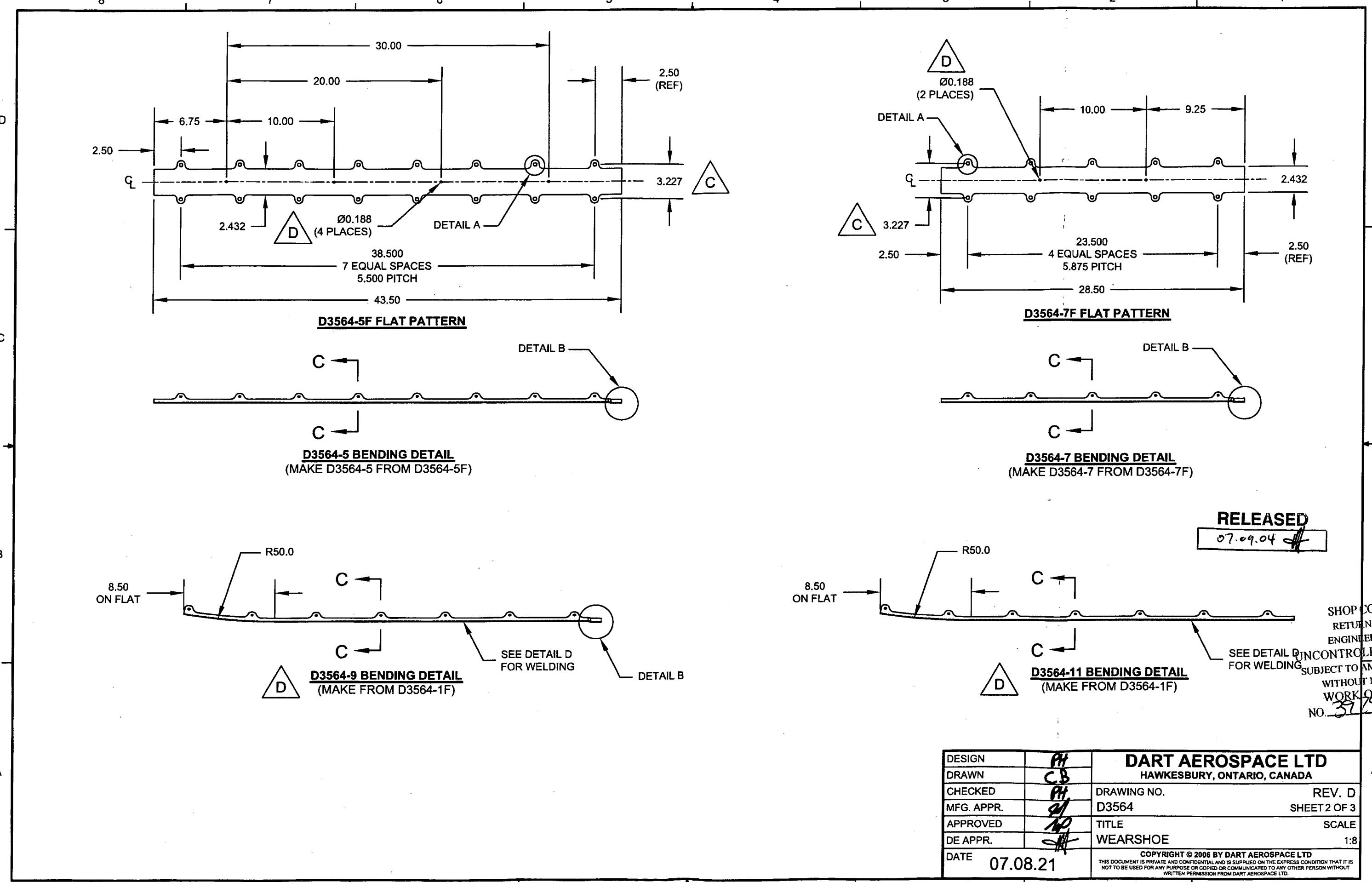
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.04.02	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM	
C	08.02.28	Dwg Rev updated	KJ/DD	AS

8 7 6 5 4 3 2 1

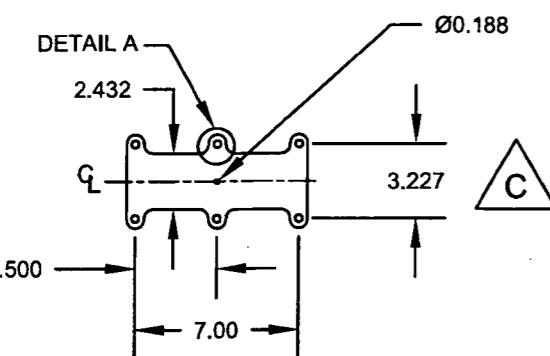


D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SJ	D3564	SHEET 1 OF 3
APPROVED	NP	TITLE	SCALE
DE APPR.	SJ	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

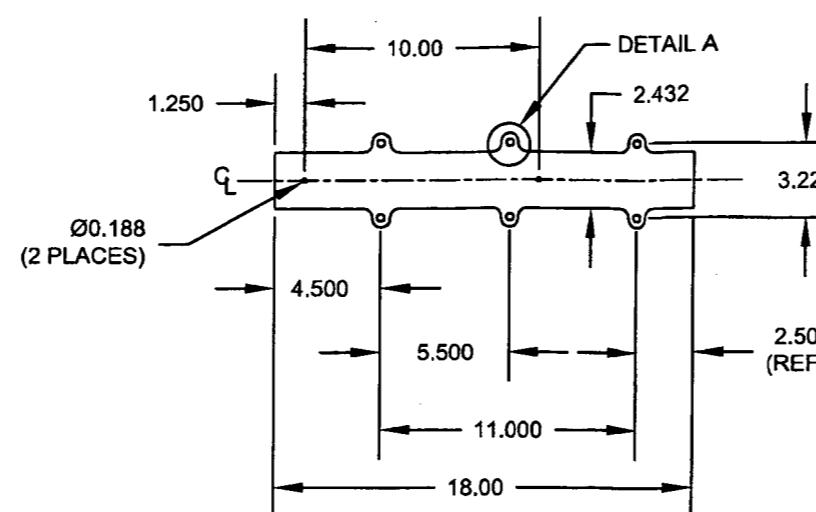
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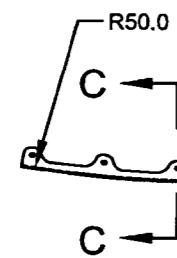
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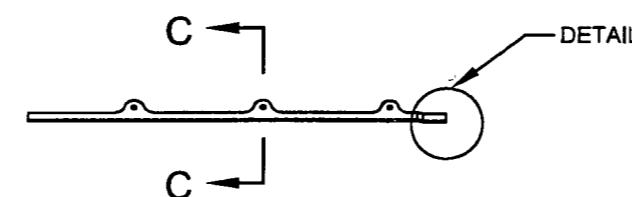
**D3564-13F FLAT PATTERN**



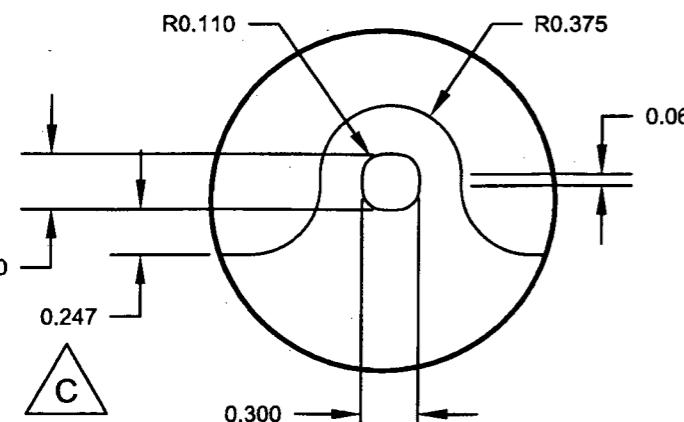
**D3564-15F FLAT PATTERN**



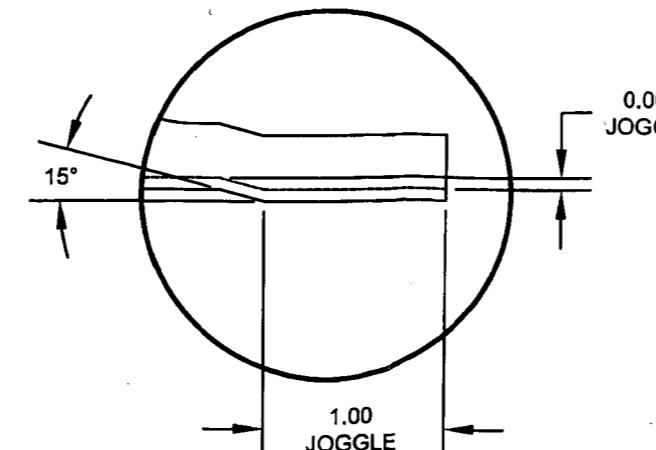
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

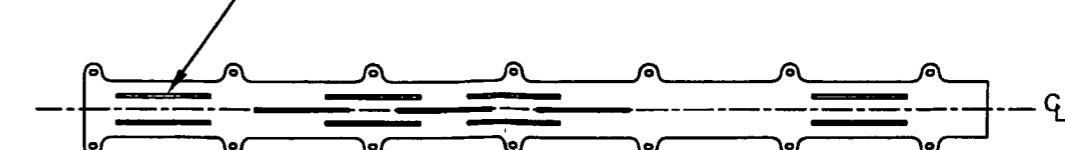


**DETAIL A**  
SCALE 1:1



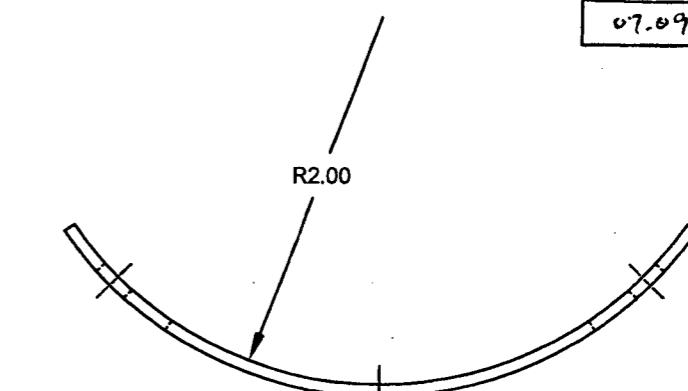
**DETAIL B**  
SCALE 1:1

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH  
(11 PLACES)  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



**DETAIL D**  
(D3564-1/3-9-11 WELDING DETAIL)

**RELEASED**  
07.09.04



**SECTION C-C**  
SCALE 1:1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39791

DESIGN	<u>PH</u>	DART AEROSPACE LTD
DRAWN	<u>CB</u>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<u>PH</u>	DRAWING NO.
MFG. APPR.	<u>SI</u>	D3564
APPROVED	<u>JO</u>	REV. D
DE APPR.	<u>SI</u>	SHEET 3 OF 3
DATE	07.08.21	SCALE
		1:8

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8 7 6 5 4 3 2 1